

Date: Tuesday, 03/02/2009 2:49:08 PM
 User: Julie Dawson

Process Sheet

02

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPLATE
 Job Number : 45476
 Estimate Number : 13770
 P.O. Number :
 This Issue : 03/02/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D3861041
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : D3861 REV.A
 Previous Run : Project Number : N/A
 Written By : Due Date : 20/02/2009 Qty: 6 Um: Each
 Checked & Approved By : JUD 09-02-04
 Comment : Est Rev:A 09-02-03 new issue DD verified by:EC
 (add 1 For Template)

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 Sheet .063



Comment: Qty.: 1.0996 sf(s)/Unit Total : 6.5974 sf(s)
 304/316 .063 Sheet
 Batch: 110551x2 18 9-2-5

2.0 WATER JET 109057 FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3861
 Dwg Rev: A
 Prog Rev: A

18 9-2-5

2-Deburr if necessary 18 9-2-5

(6)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Sort 02/05 (x6)

5.0 D30093 Cup



Comment: Qty.: 6.0000 Each(s)/Unit Total : 36.0000 Each(s)
 CUP
 Batch: 3 423.76 BE 09/03/18 (36)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 03/02/2009 2:49:08 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 45476

Part Number: D3861041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld D3009-3 cups as per dwg D3861

A/R 316L stainless steel rod

Batch:

m109213 BE 09/03/18

2-Weld hard facing as per Dwg D3861

A/R 2059B Hard Coat rod

Batch:

m111036 EL 9-4-29

7.0

QC9

VISUAL WELDING INSPECTION



6

Comment: VISUAL WELDING INSPECTION

lpl 09-04-30

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

50260130 X6

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

11:20

OVEN TEMPERATURE:

320°

FINISH TIME:

11:50

UMD/ FL

09/04/30 X6

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-04-30

X6

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart P/N and B/N using a permanent fine point marker as indicated on dwg, then Stock

Location: *500*

915h

SP

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/04 X6

Job Completion



MF 09-05-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

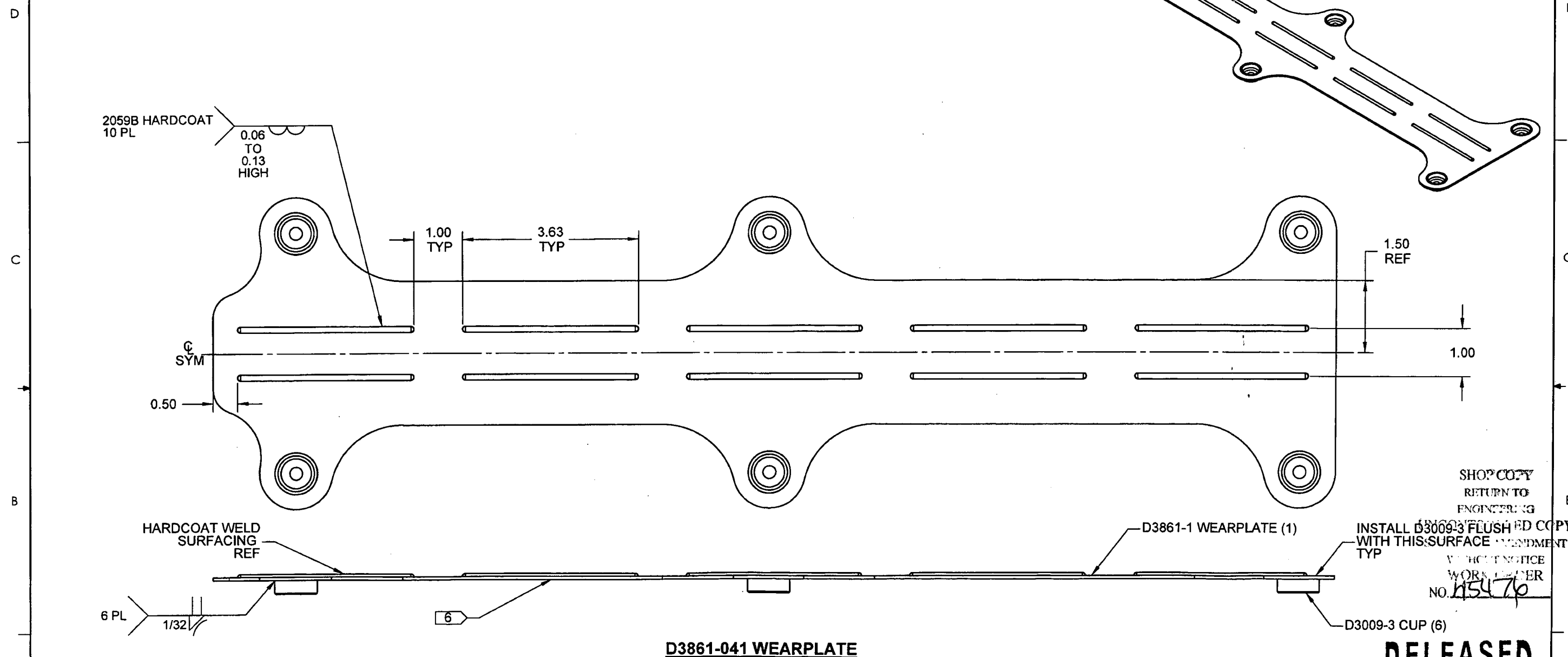
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

FIRST ARTICLE INSPECTION CHECKLIST

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3861-041	WEARPLATE
2	1	D3861-1	WEARPLATE
3	6	D3009-3	CUP

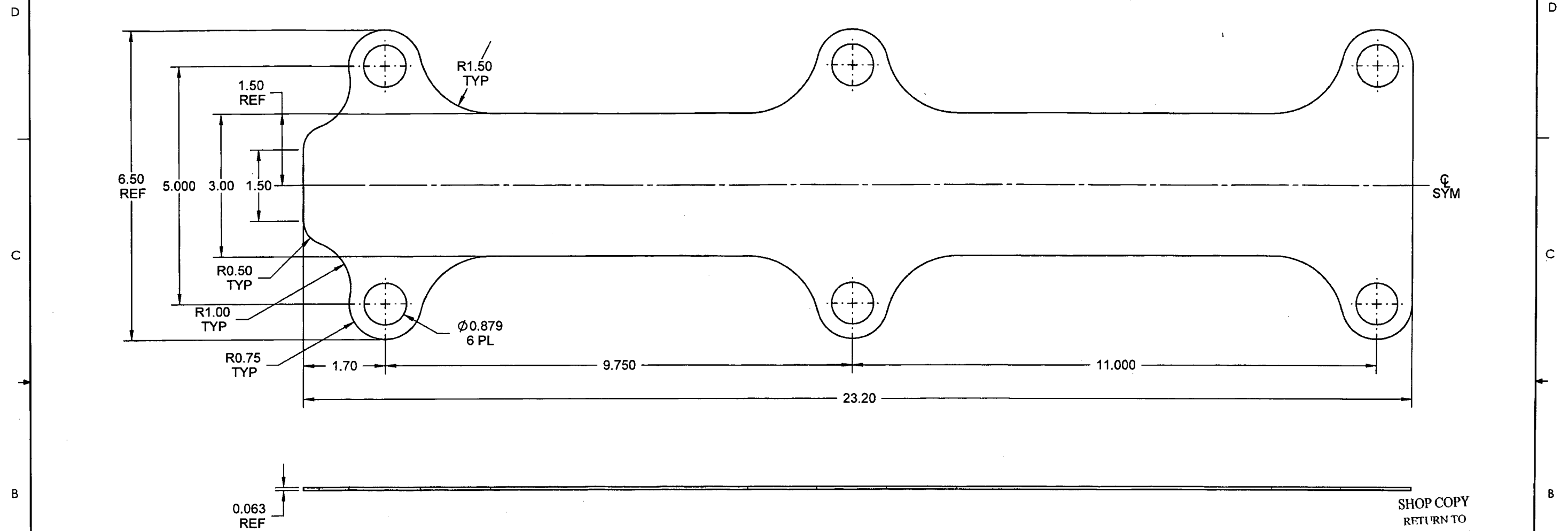


NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3861-041" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.69 lbs
- 8) WELD PER DART QSI 004

A	NEW ISSUE		09.01.26
REV.		DESCRIPTION	BY DATE
DESIGN	JS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JS		
CHECKED	JS		
MFG. APPR.	JS		
APPROVED	JS		
DE APPR.	JS		
DATE	09.01.26		
		DRAWING NO.	REV. A
		D3861	SHEET 1 OF 2
		TITLE	SCALE
		WEARPLATE	NTS
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8 7 6 5 4 3 2 1



D3861-1 WEARPLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
NO. 45476

RELEASED
09.01.26

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK) PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524 (REF DART SPEC M304S16GA)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.52 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3861	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
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8 7 6 5 4 3 2 1